

Date: Wednesday, 20/05/2009 11:23:02 AM
 User: Melanie Fauteux









Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 48080		
Estimate Number	: 10675		
P.O. Number	:	Part Number	: D3443041
This Issue	: 20/05/2009 S.O. No. :	Drawing Number	: D3443 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 46725	Material	:
Written By	:	Due Date	: 27/05/2009 Qty: 5 Um: Each
Checked & Approved By	: <u>MF 09-05-20</u>		
Comment	: EST REV. A 05.11.17 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34431	Lug
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	D3443-1	lug
Batch <u>B46750</u> = 5x <u>SP 09.05.20</u> 09.05.20 09.05.20		
2.0	D34435	Tubing
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	D3443-5	Tubing
Batch <u>B46751</u> = 5x <u>SP 09.05.20</u>		
3.0	D34531	Clevis
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick:		
Qty	Part Number	Description
1	D3453-1	Clevis
Batch <u>B46144</u> = 5x <u>SP 09.05.20</u>		
4.0	238805	SS DOWEL PIN 3/4" LONG
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)		
Pick:		
Qty	Part Number	Description
2	238-805	SS DOWEL PIN 3/4" LONG
Batch <u>M111089</u> = 10x <u>SP 09.05.20</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 48080

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3443

SP 09.05.21 (5)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-21 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/21 (5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M111472

START TIME:

8:10am

OVEN TEMPERATURE:

400°C

FINISH TIME:

8:40am

JH 09-05-26 (5)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-26 (5)

10.0

63215K32

Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1

63215K32

Spherical Bearing

M111278

9/5/26

SK (5)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

FF 09-05-28 (5)

W/O: /		WORK ORDER CHANGES					
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Process Sheet

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Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 48080

Part Number: D3443041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/28 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 09/05/28 (5)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/28 JF

Job Completion



MF
09-05-28

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

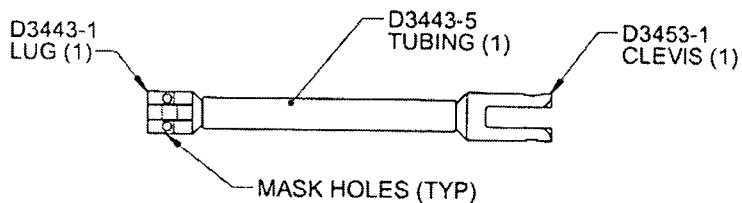
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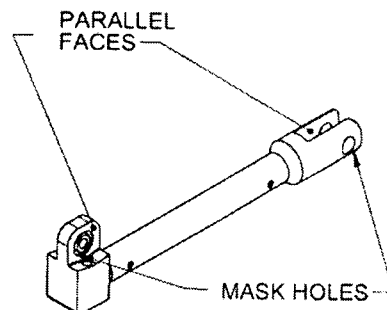
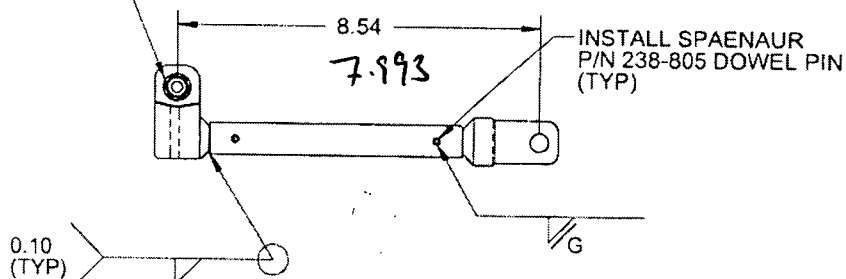
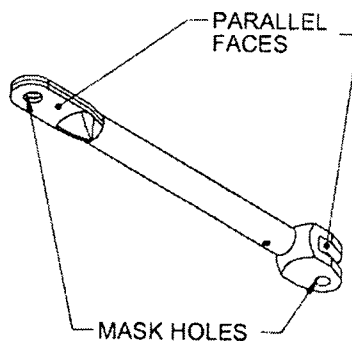
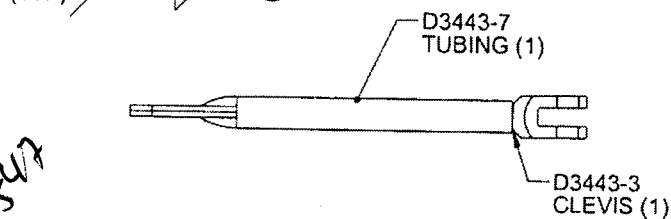
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED

05.12.05 *[Signature]*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

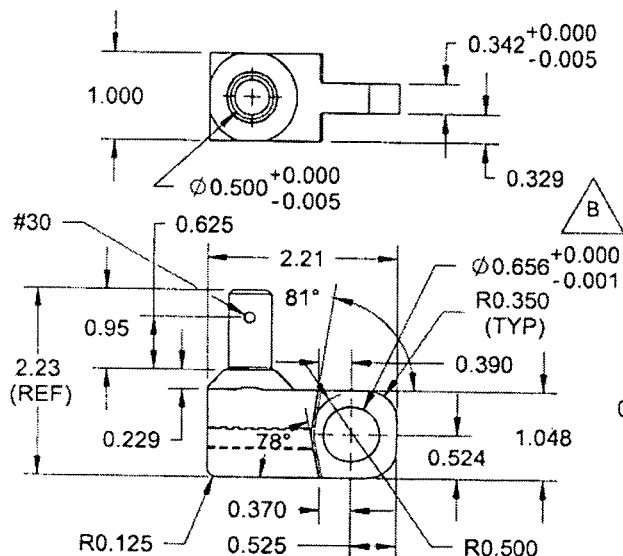
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

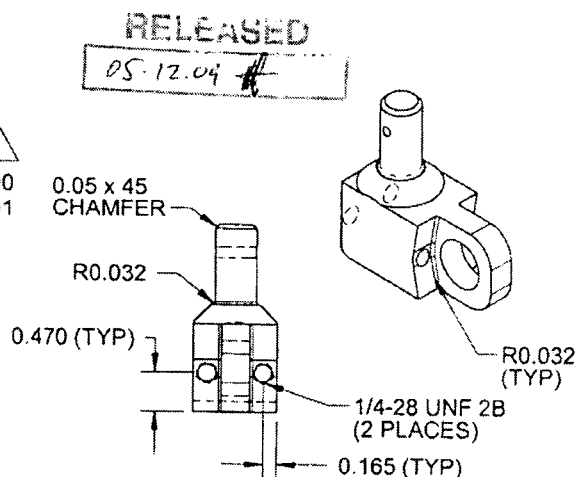
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2	

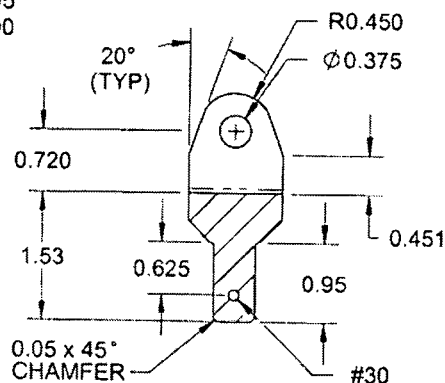
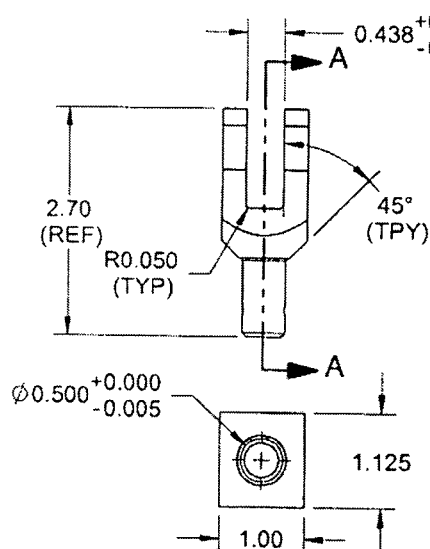


D3443-1 LUG



D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS



D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- GENERAL NOTES:
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

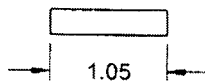
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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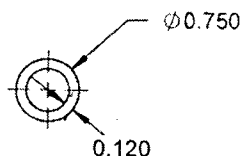
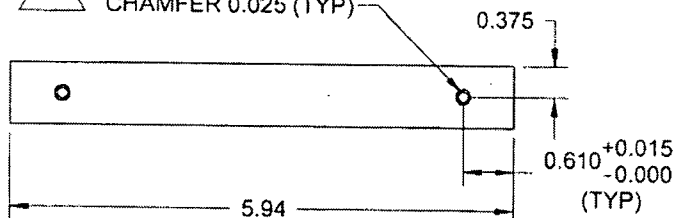
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

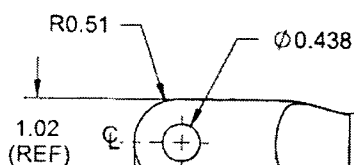
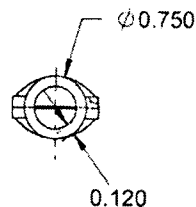
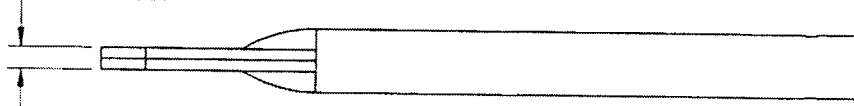
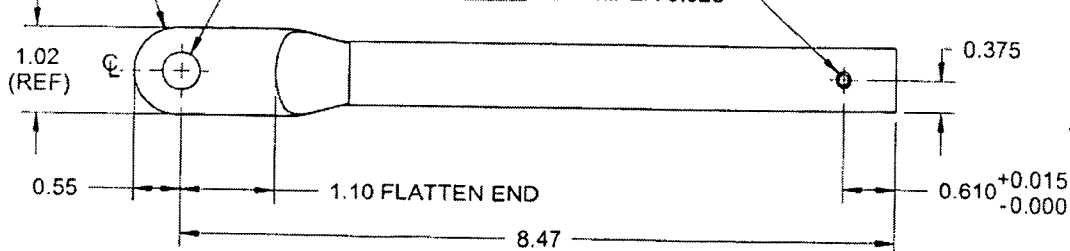
 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

RELEASED

05.12.09

D3443-5 TUBING $0.260^{+0.000}_{-0.030}$ DRILL $\phi 0.125$ THRU
CHAMFER 0.025**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries